

Date: Tuesday, 07/04/2009 10:18:24 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number :	46954	Part Number :	D2573		
Estimate Number :	10533	Drawing Number :	D2573 REV E		
P.O. Number :		Project Number :	N/A		
This Issue :	07/04/2009	S.O. No. :			
Prsht Rev. :	NC	Drawing Revision :	E		
First Issue :	//	Type :	MACHINED PARTS		
Previous Run :	45923	Material :			
Written By :		Due Date :	24/04/2009	Qty:	10 Um: Each
Checked & Approved By :	<u>JLD 09-04-07</u>				
Comment :	Est: I As Per RevE 06-01-27 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101007	Saddle Billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 7075-T7351 8.25X7.75X2.5
 Make from D6101-007 billet for D2573
 Ensure that grain is along 7.75" length
 Batch No: 46412

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 46954 Double check by: mmf

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

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Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

28 09/04/18 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

11 09-09-20 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M110939

START TIME:

12:00

OVEN TEMPERATURE:

320°

FINISH TIME:

12:30

PK 09-04-20 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

S. 09/04/20 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5.434

PK 09-04-21

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 (10)

Job Completion



MF 09-04-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46954
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.438	.438	.440		
B	1.745	1.755		1.750	1.746	1.746	1.748		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.746	1.746	1.748		
E	7.990	8.010		7.999	8.003	8.004	8.003		
F	0.490	0.510		.503	.501	.500	.503		
G	0.257	0.262		.259	.259	.258	.258		
H	0.375	0.380		.376	.376	.377	.377		
I	0.490	0.510		.502	.501	.500	.499		
J	1.174	1.184		1.179	1.179	1.177	1.178		
K	0.558	0.578		.568	.568	.563	.563		
L	1.174	1.184		1.179	1.179	1.179	1.178		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.502		
O	4.119	4.129		4.124	4.124	4.124	4.120		
P	0.115	0.135		.125	.125	.124	.124		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.250		
S	0.115	0.135		.123	.121	.133	.134		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.228	3.227		
V	0.230	0.250		.244	.242	.243	.241		
W	0.115	0.135		.126	.129	.127	.128		
X	0.308	0.313		.310	.311	.311	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.371	.370	.371		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.634	.623	.624	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.245	.247	.249		
AE	1.500	1.520		1.515	1.515	1.514	1.513		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.265	.270		
AH	0.240	0.260		.250	.249	.249	.250		
AI	2.000	2.020		2.002	2.002	2.002	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	J.L.
Date:	09/04/15

Audited by:	JP
Date:	09/04/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46954
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1 5	2 6	3 7	4 8		
A	0.438	0.443		.438	.439	.440	.440		
B	1.745	1.755		1.745	1.747	1.748	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.747	1.748	1.750		
E	7.990	8.010		8.003	8.004	8.003	8.000		
F	0.490	0.510		.490	.505	.502	.507		
G	0.257	0.262		.258	.258	.258	.260		
H	0.375	0.380		.377	.377	.377	.377		
I	0.490	0.510		.501	.501	.501	.501		
J	1.174	1.184		1.178	1.177	1.178	1.178		
K	0.558	0.578		.564	.565	.569	.569		
L	1.174	1.184		1.178	1.179	1.178	1.178		
M	1.365	1.375		1.368	1.370	1.368	1.368		
N	2.495	2.505		2.500	2.500	2.499	2.500		
O	4.119	4.129		4.121	4.122	4.123	4.125		
P	0.115	0.135		.124	.124	.127	.130		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.251	.252	.251		
S	0.115	0.135		.127	.128	.129	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.225	3.225	3.227	3.226		
V	0.230	0.250		.244	.245	.243	.245		
W	0.115	0.135		.127	.131	.124	.128		
X	0.308	0.313		.311	.310	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.371	.369	.367	.369		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.623	.624	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.245		
AE	1.500	1.520		1.513	1.514	1.517	1.515		
AF	0.115	0.135		.125	.123	.115	.135		
AG	0.240	0.280		.280	.280	.280	.270		
AH	0.240	0.260		.247	.247	.245	.248		
AI	2.000	2.020		2.003	2.004	2.007	2.005		
AJ	0.023	0.043		.033	.035	.033	.033		
Accept/Reject									

Measured by:	J.L
Date:	09/04/18

Audited by:	815
Date:	09/04/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46954
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.000				
F	0.490	0.510		.510	.506				
G	0.257	0.262		.258	.259				
H	0.375	0.380		.377	.376				
I	0.490	0.510		.503	.505				
J	1.174	1.184		1.178	1.179				
K	0.558	0.578		.567	.572				
L	1.174	1.184		1.178	1.179				
M	1.365	1.375		1.369	1.370				
N	2.495	2.505		2.500	2.500				
O	4.119	4.129		4.121	4.124				
P	0.115	0.135		.126	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.251				
S	0.115	0.135		.128	.126				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.226	3.230				
V	0.230	0.250		.245	.241				
W	0.115	0.135		.126	.128				
X	0.308	0.313		.316	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.367	.370				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.625	.623				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.247	.244				
AE	1.500	1.520		1.516	1.517				
AF	0.115	0.135		.125	.135				
AG	0.240	0.280		.275	.260				
AH	0.240	0.260		.246	.248				
AI	2.000	2.020		2.004	2.006				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

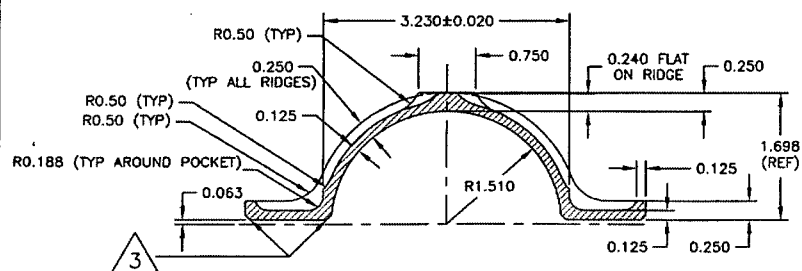
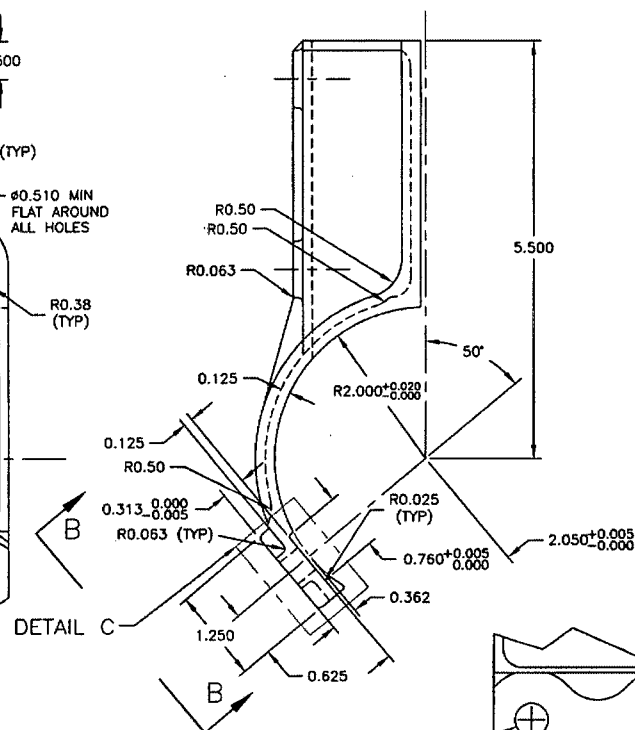
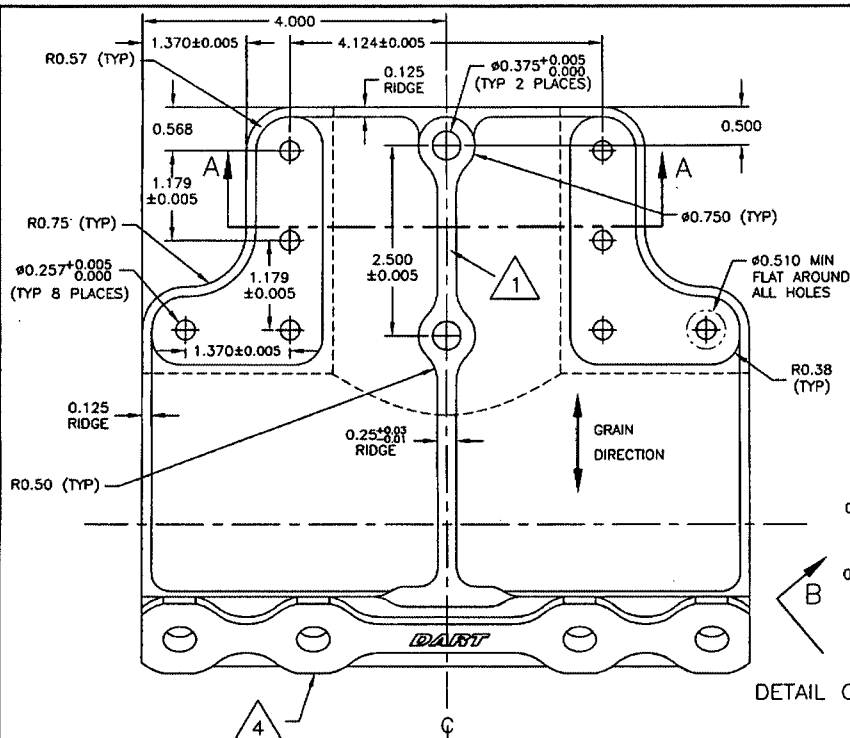
Measured by:	JL
Date:	09/04/18

Audited by:	SB
Date:	09/04/18

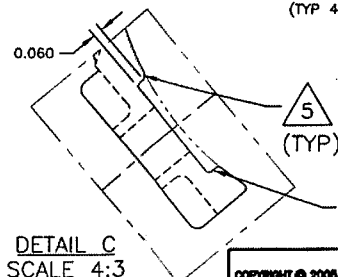
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.06



SECTION A-A



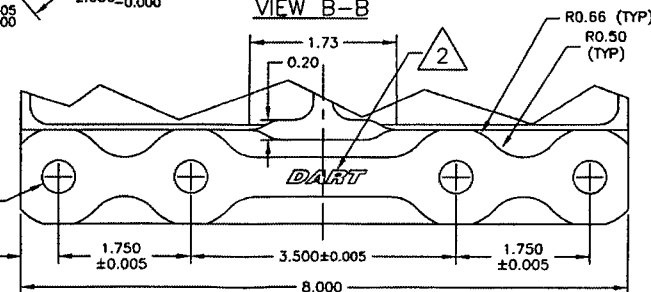
DETAIL C
SCALE 4:3

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2573
		TITLE OUTER AFT SADDLE
		SCALE 2:3

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HAMPSHIRE, ONTARIO, CANADA
REV. E
SHEET 1 OF 1